

Date: Wednesday, 1/31/2007 2:18:20 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SPACERS (1/4 THICK)
Job Number	30543		
Estimate Number	10247		
P.O. Number	N/A	Part Number	D2022101
This Issue	1/31/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2022 REV. --
First Issue	N/A	Project Number	N/A
Previous Run	27688	Drawing Revision	-
Written By		Material	N/A
Checked & Approved By	<u>DK</u> 07.02.01	Due Date	2/20/2007
Comment	Est D 02/03/07 Now made in house NG	Qty:	400
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750"
Comment: Qty.: 0 f(s)/Unit Total : 13 f(s) 6061T6 Round Bar .750" Material: 6061-T6 (QQ-A-225/8)x.750Ø bar (M6061T6R0.750) Batch: <u>1603156</u> SF 07/02/18		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1- Note: .257(F) Dia drill 2-Turn Blank as per FolioFA206 3-Tumble & deburr any sharp edges as per dwg SF 07/02/18		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SF 07/02/18		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK SF 07/02/18		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ P 07/02/20 (500)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACERS (1/4 THICK)

Job Number: 30543

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(500)

Comment: FINAL INSPECTION/W/O RELEASE

1/31/07/22

Job Completion



U 07-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30543
Description: Spacer	Part Number:	D2022-101
Inspection Dwg: D2022	Rev: -	Page 1 of 1

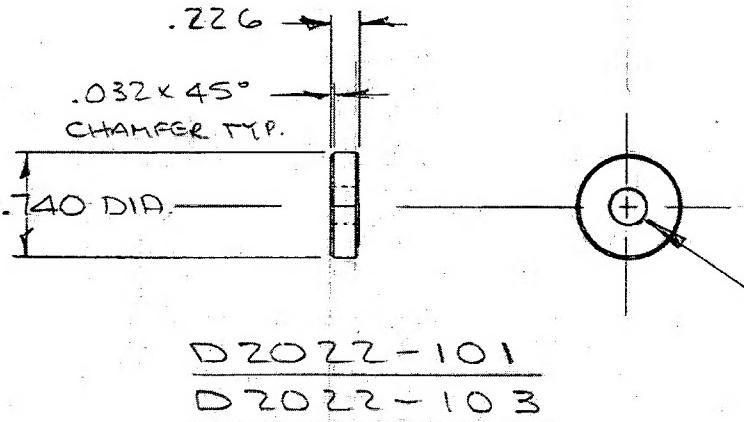
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.B	Audited by:	gml	Prototype Approval:	N/A
Date:	07/02/18	Daté:	07/02/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	KJ/JLM	SJL

RELEASED
170119 BW



DRILL 'F' (.257) DIA IN - 101
DRILL P (.323) DIA IN - 103

MAT'L : ALUMINUM 6061-T6 (QQ-A-225/8)



D2022

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
D2022-103	SPACER 5/16 ALUM. 6061-T6	QQ-A-225/8		
D2022-101	SPACER 1/4 ALUM 6061-T6	QQ-A-225/8		

DART AERO ACCESSORIES INC

DRAWN BY	BRADLEY	DATE
DESIGN	BRADLEY	600115
STRESS		
CHECKED		
CLIENT		
CODE	DWG NO.	REV.
	D2022	
SCALE	1:1	SHT 1 OF 1

SPACERS

NO. 30543 WORK ORDER ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE	SHOP COPY												
	RETURN TO												
	DRAWN												
APPROVED	REVISION												
THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.													
REQUIREMENTS — UNLESS OTHERWISE SPECIFIED													
<table border="1"> <tr> <td colspan="2">GENERAL</td> </tr> <tr> <td colspan="2">1. DIMENSIONS ARE IN INCHES 2. USE ASME Y14.5M-1994 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER IN. - 5 - 7742 5. HOLES PER IN. 10287</td> </tr> <tr> <td colspan="2">2. TOLERANCES — JIS E 0300 JIS E 010 3. ANGLES: 4. PARALLELISM: 5. POSITIONAL: 6. SYMMETRY ABOUT: ALL MISC CENTRE LINE .005</td> </tr> <tr> <td colspan="2">BASIC CODES</td> </tr> <tr> <td colspan="2">D-COMPL COUNTERSINK W-SLOT</td> </tr> <tr> <td colspan="2">LENGTH DASH NO. W-SLOT</td> </tr> </table>		GENERAL		1. DIMENSIONS ARE IN INCHES 2. USE ASME Y14.5M-1994 3. REMOVE SHARP EDGES .015 MAX. 4. THREADS PER IN. - 5 - 7742 5. HOLES PER IN. 10287		2. TOLERANCES — JIS E 0300 JIS E 010 3. ANGLES: 4. PARALLELISM: 5. POSITIONAL: 6. SYMMETRY ABOUT: ALL MISC CENTRE LINE .005		BASIC CODES		D-COMPL COUNTERSINK W-SLOT		LENGTH DASH NO. W-SLOT	
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LENGTH DASH NO. W-SLOT													
REPORT ALL DISCREPANCIES — DO NOT SCALE													